

Slp 29/12

Work Order ID 78051

78051

Page 1

December-28-11 9:05:27 AM

Item ID: D4092-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Maintenance Step Assembly 3
 Start Date: 12/28/11 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/28/11 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4092	B

100	Pick Kit	0.00
100		
Packaging	Memo	0.00
Packaging		

110		0.00
110		
Small Fab	Memo	0.00
Small Fab	Assemble as per Dwg	
	Torque screws up to 15-25 in- lbs	

120	QC5- Inspect part completeness to step on W/O	0.00
120		
QC	Memo	0.00
Quality Control		

EP 12/02/15 (3)

EP 12/02/15 (3)

(3)

8/26/15

Work Order ID 78051

December-28-11 9:05:27 AM

78051

Page 2

Item ID: D4092-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Maintenance Step Assembly
 Start Date: 12/28/11 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/28/11 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

3x SP 12-02-15

M.L.S 12/02/15

12-02-15 3

Picklist Print

December-28-11 9:05:26 AM

74203 Page 1 12

Work Order ID: 78051

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 12/28/11

Required Date: 12/28/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD
639 JLM VERIFIED BY:DD

IPP REV:B AS PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 Maintenance Step		Manufactured	No				Each	3.0000		2		12/02/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST241A		3						B 78 234 (5X)	
				74303		1						B 77 852 (1X)	
				77189		2							
D4093-1 Bracket		Manufactured	No				Each	0.0000		1		12/02/15	
								B 77853					
D4093-3 Bracket		Manufactured	No				Each	0.0000		1		12/02/15	
								B 77850					
D4093-5 Bracket		Manufactured	No				Each	6.0000		2		12/02/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST124		6						B 800 85 (6X)	
				74998		6							
MS24694-S54 Screw		Purchased	No				Each	116.0000		2		12/02/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST289A		116						M/20142 (6X)	
				118078		16							
				119124		100							
MS24694-S55 Screw		Purchased	No				Each	73.0000		8		12/02/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST289A		73							
				119307		73							

Picklist Print

December-28-11 9:05:26 AM

Page 2

Work Order ID: 78051

Parent Item: D4092-042

Parent Item Name: Maintenance Step Assembly

Start Date: 12/28/11

Required Date: 12/28/11

Start Qty: 1.00

Required Qty: 1.00

MS24694-S56 Purchased No Each 33.0000
SCREW

Location Loc Qty Loc Code

ST289A 33

104407 33

NAS1149D0332J Purchased No Each 2,451.0000
Washer

Location Loc Qty Loc Code

ST298 2451

105793 12

110985 4

117087 89

118384 346

119042 1000

119717 1000

MS21042L3 Purchased No Each 6,837.0000
Nut

Location Loc Qty Loc Code

ST300 6837

117441 16

117885 32

118451 5

118927 3

119017 5988

119075 793

2 EP 12/02/15

6
12 EP 12/02/15

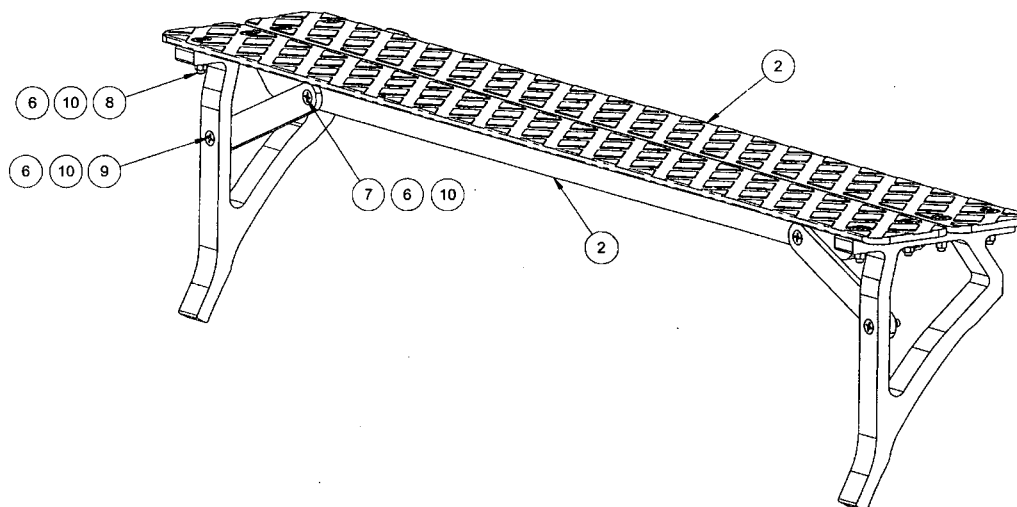
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12 EP 12/02/15

36

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Shop Packet Print

Page 2







D4092-041 MAINTENANCE STEP ASSEMBLY

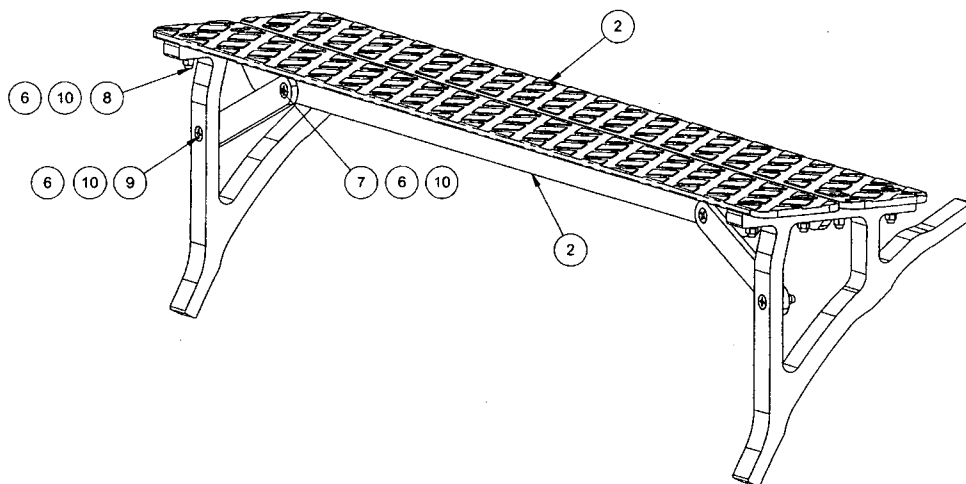
B

RELEASED
2011-09-22

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4092	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MAINTENANCE STEP ASS'Y	NTS
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WLO 78051



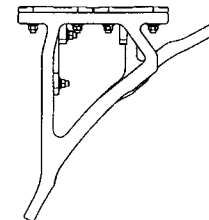
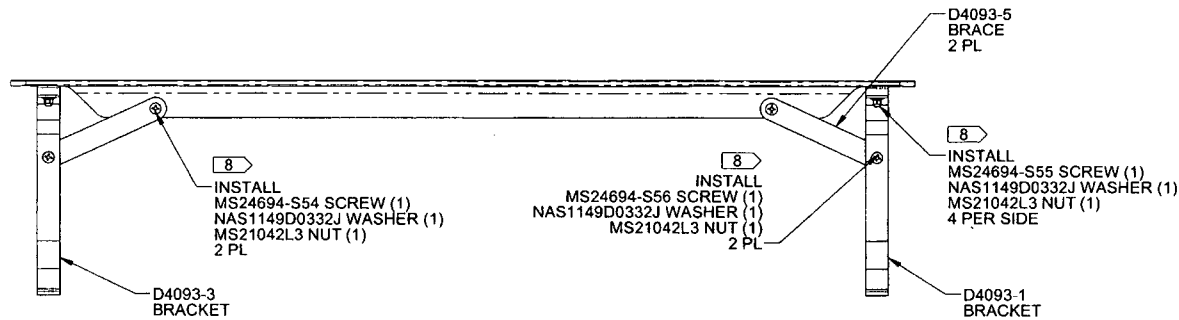
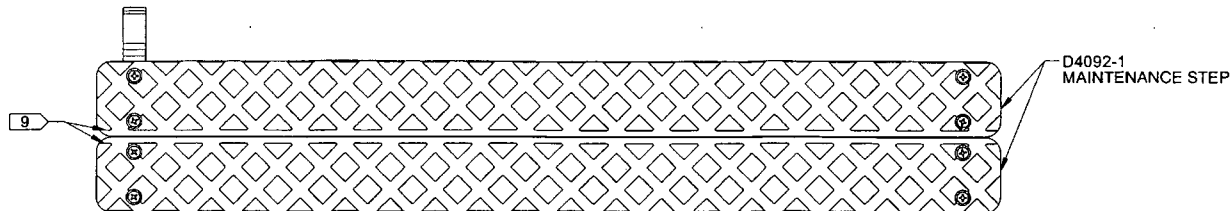
D4092-042 MAINTENANCE STEP ASSEMBLY



ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

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2011-09-22
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MFG. APPR.	<i>MD</i>	D4092	SHEET 2 OF 6
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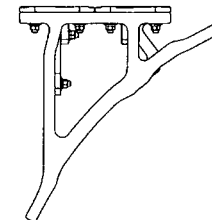
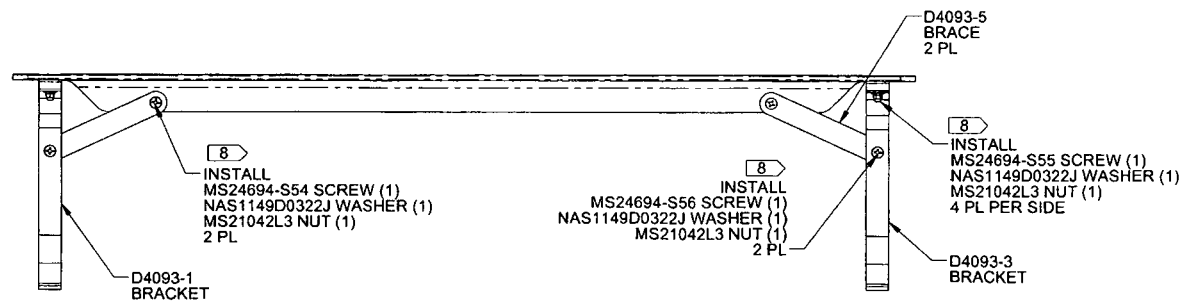
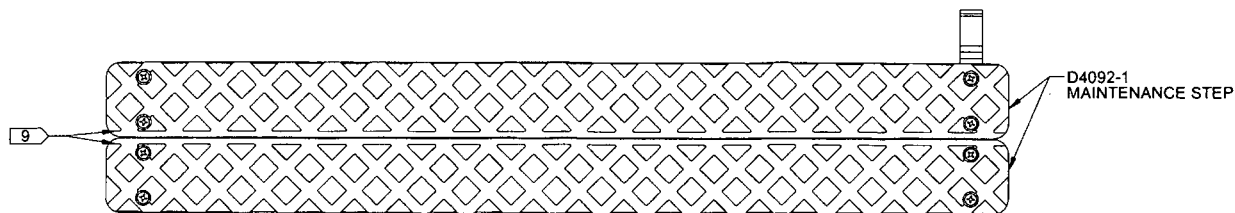
D4092-041 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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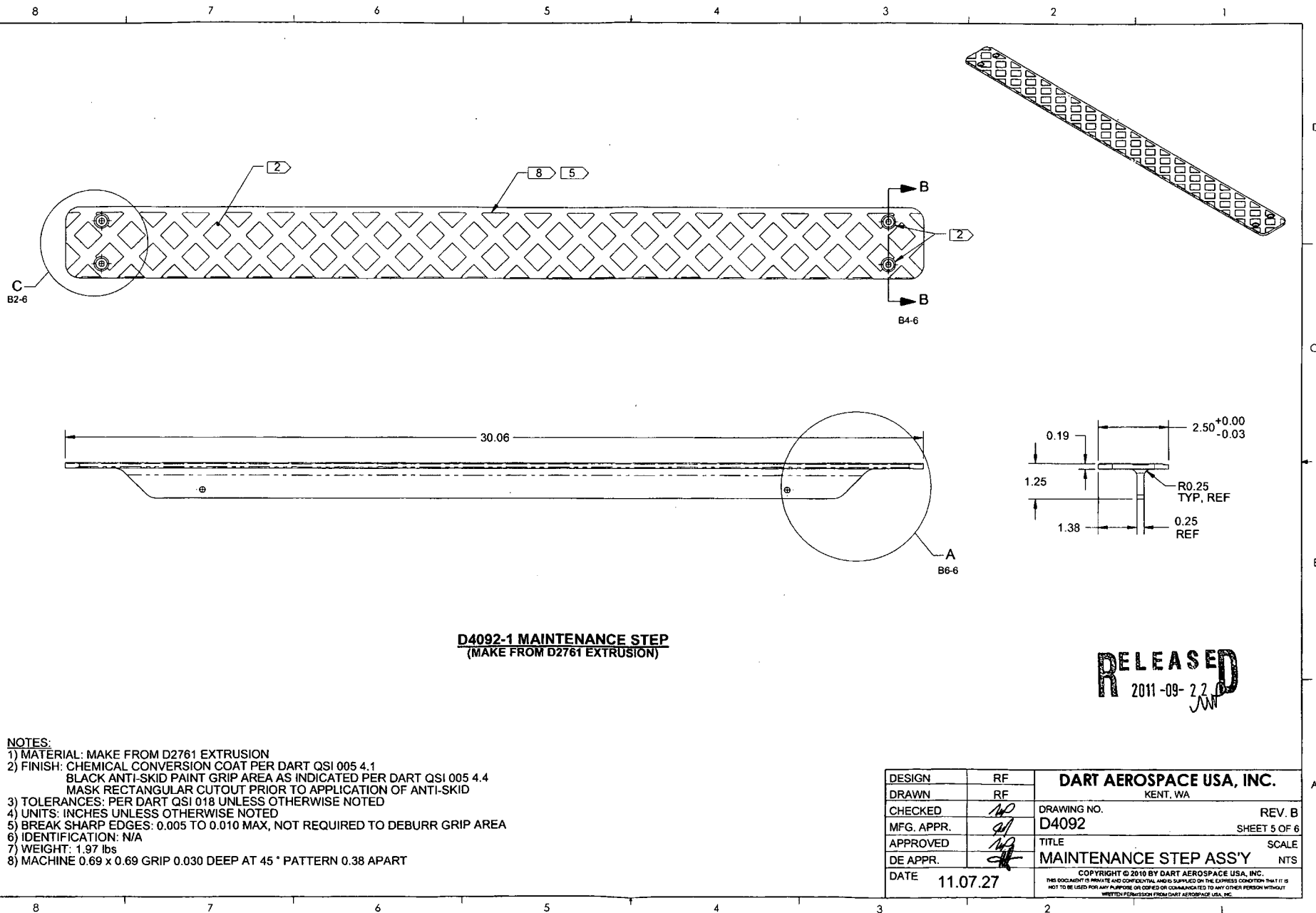
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2011-09-22

D4092-042 MAINTENANCE STEP ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

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MFG. APPR.	<i>MP</i>	D4092	SHEET 4 OF 6
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D4092-1 MAINTENANCE STEP
(MAKE FROM D2761 EXTRUSION)

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2011-09-22
JWW

NOTES:

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

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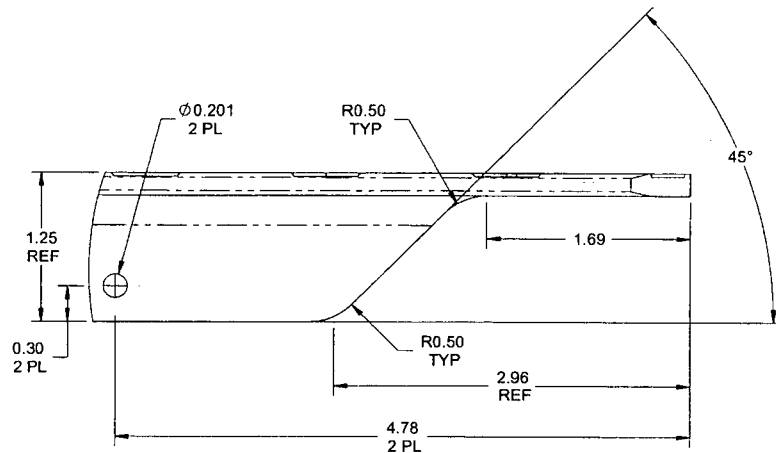
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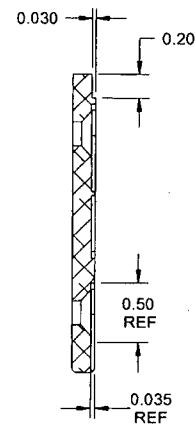
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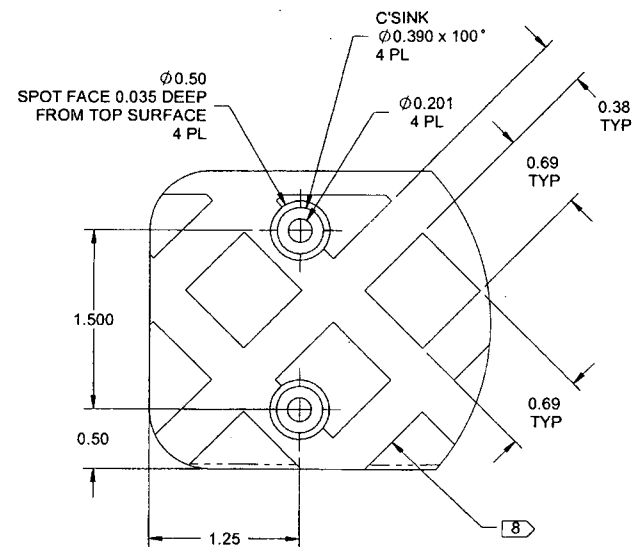
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DETAIL A B3-5
SCALE 3X, TYP



SECTION B-B C3-5
SCALE 3X, TYP



DETAIL C C8-5
SCALE 3X, TYP

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2011-09-22
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MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
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8 7 6 5 4 3 2 1